

Work Order ID 69781

Thursday, May 19, 2011 8:56:33 AM

Page 1

Item ID: D407-559-113

Accept

Revision ID:

Item Name: Bearpaw, Large

Start Date: 5/19/2011 Start Qty: 10.00

Required Date: 5/24/2011 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

11-05-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D206-559

L

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPPD407-559-113 CHG003

Fulaker

ck per cl 11/05/25

160

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

JB 11/05/25

170

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

Fulaker

LID

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D407-559-113

Accept

Setup Start

Revision ID:

Stop

Item Name: Bearpaw, Large

Start Date: 5/19/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD407-559-113

Location: _____

Revd

11/15 100

190

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

OK 11/07/15

MF
11-07-15

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Thursday, May 19, 2011 8:56:40 AM

Page 1

Work Order ID: 69781

Parent Item: D407-559-113

Parent Item Name: Bearpaw, Large




Start Date: 5/19/2011

Required Date: 5/24/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: New issue DD 09.10.29 verified by:EC
 IPP RevB: ECN09-698p DD 09.11.03 verified by:EC
 as per revision K DD 09.11.24 verified by:EC
 per ECN10-575 DD verf:EC
 IPP RevC: IPP Rev:D 10.05.27
 IPP REV:E 11-04-11 PER INN REV L JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2274  Radius Block		Manufactured	No			160	Each	443.0000	16	160	✓		
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
ST010 443													
67578 204													
68937 4													
68942 235													
D3456-1  Washer		Manufactured	No			160	Each	71.0000	8	80	✓		
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
FG 7													
25701 7													
ST054 64													
66848 6													
68748 58													
D4011-1  Clamp, Short		Manufactured	No			160	Each	45.0000	8	80	✓		
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
ST458 45													
53978 45													

67578
 63239X1
 69777 20X
 68748X54
 53832X14 JB
 53178X2
 53978X35
 69784 296

11/05/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 69781

Parent Item: D407-559-113

Parent Item Name: Bearpaw, Large

Start Date: 5/19/2011

Required Date: 5/24/2011

Start Qty: 10.00

Required Qty: 10.00

D4011-5
Clamp, Short

Manufactured No 160 Each 32.0000

8 80 ✓
69785 32x JB

Location Loc Qty Loc Code

ST459 32
53980 32

D4012-1
Cushion

Manufactured No 160 Each 48.0000

8 80 ✓
53980 x 48
57716 x 16 JB

Location Loc Qty Loc Code

ST459 48
57913 32
63724 16

D4355-1
Bearpaw

Manufactured No 160 Each 0.0000

2 20 ✓
6978 16x JB

D4360-041
Wearplate Assembly

Manufactured No 160 Each 0.0000

2 20 ✓
6978 16x JB

AN4C11A
bolt

Purchased No 160 Each 52.0000

8 180 ✓
117793 x 5 JB 11/05/25

Location Loc Qty Loc Code

MEZZ 52
107013 20
19600 32

107013 x 20
19600 x 1

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 69781

Parent Item: D407-559-113

Parent Item Name: Bearpaw, Large

Start Date: 5/19/2011

Required Date: 5/24/2011

Start Qty: 10.00

Required Qty: 10.00

AN4C20A

Purchased

No

160

Each

84.0000

16

160

Bolt

Location

Loc Qty

Loc Code

ST359

84

113928

84

Purchased

No

160

Each

160.0000

16

160

AN4C21A

BOLT

Location

Loc Qty

Loc Code

ST358

160

117441

160

Purchased

No

160

Each

1,258.000

24

240

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

600

117423

600

ST301

618

116188

-12

116549

130

117601

500

117793 X 81 JB

113928 X 79

117793 X 12 JB

117441 X 148

117423

JB 11/05/25

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Shop Packet Print

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

Work Order ID: 69781

Parent Item: D407-559-113

Parent Item Name: Bearpaw, Large

Start Date: 5/19/2011

Required Date: 5/24/2011

Start Qty: 10.00

Required Qty: 10.00

NAS1149D0463J

Purchased

No

160

Each

3,964.000

16

160



Washer



JB 11/05/25

Location

Loc Qty

Loc Code

FP-B

8

116805

8

ST298

3956

116805

0

117291

1356

117460

1600

117591

1000

117291

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP